

Thursday, 02/04/2009 1:27:11 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET RIB
Job Number	: 46867	Part Number	: D31661
Estimate Number	: 10402	Drawing Number	: D3166 REV.A2
P.O. Number	:	Project Number	: N/A
This Issue	: 02/04/2009	Drawing Revision	: A2
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 08/04/2009
Previous Run	: 46628	Qty:	12
Written By	:	Um:	Each
Checked & Approved By	: <u>JUL 09. 04.02</u>		
Comment	Est. A 02.08.23 New issue KJ Est: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC Est Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 5.2500 f(s)/Unit Total : 63.0000 f(s) 304 SQ Tube.75x.75x.065W (M304TS0750W065)	
		Material: 304/316 SS tube 0.065" wall Batch <u>M11148</u> SAD 09-04-05	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 Cut 3/4" x 3/4" square tubing 60.00" long.	<u>SAD 09-04-05</u> (F2)
3.0	BENDING	BENDING MACHINE - SKIDTUBES	 <i>[Handwritten signature]</i> 9-4-06 (DIO)
		Comment: BENDING MACHINE	
		-Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.	9-4-06
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)	<u>D 09-04-06 (9)</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Basket</u>	<u>D 09-04-06 (9)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/04/06

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 46867		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9-4-06	3	3pcs Scrap tried to improve bond R.O.C. continuous improvement	BSW	-Scrap & destroy. -No replace.	D 9-4-06	P 09-04-06	BSW	KW

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 1:27:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 46867

Part Number: D31661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 9.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

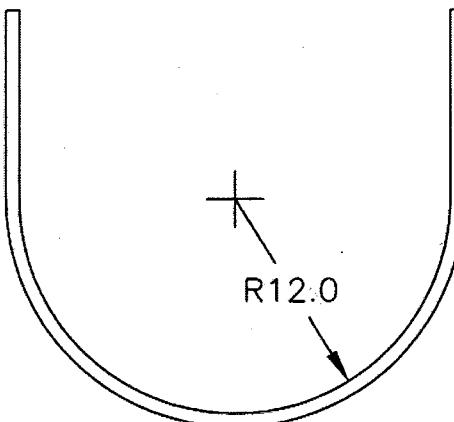
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

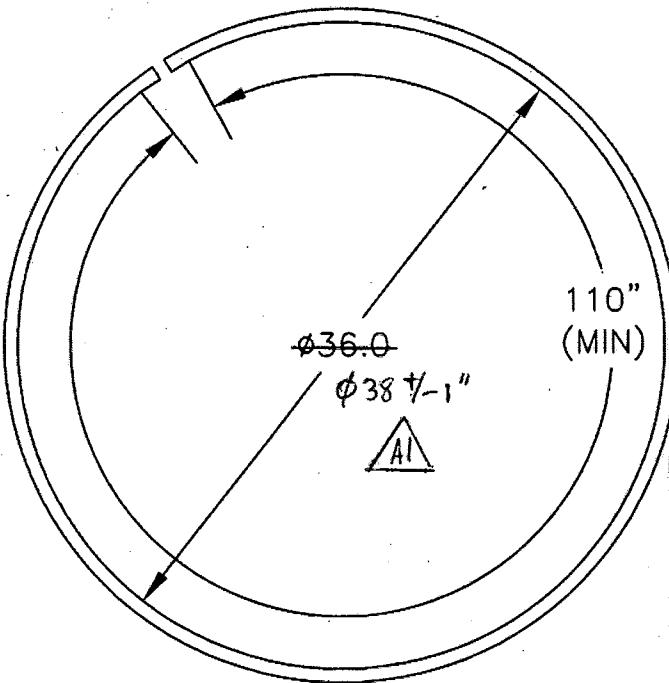
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A 02.07.10		NEW ISSUE	
A1 04.04.08		38+/- 1 WLS 36.0	

RELEASED
 02.08.06


10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 46867D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3166	TITLE BASKET HOOP	REVA1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>M</i>		MFG. APPR. <i>M</i>	APPROVED <i>M</i>	DE APPR. <i>M</i>		
DATE 08.12.11	DATE 08.12.15		DATE 08/12/15	DATE 08/12/16		DATE 08.12.16	

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO WORK ORDER

SHOP COPY
RETURN TO
ENGINEERING

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)

REASON: SEE PAR 08-005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries